

# Work Order ID 83935

\*83935\*

Page 1

Item ID: D2804-041

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Bracket Assembly

Start Date: 27/04/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 11/05/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/04/27

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2804	Rev C

100		0.00							
-----	--	------	--	--	--	--	--	--	--

\*100\*

Small Fab

Small Fab

Memo

0.00

Small Fab

Press D2805-1 Into arm as per Dwg D2804

6X 12/06/05

110	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

\*110\*

QC

Memo

0.00

Quality Control

6 12/06/05

120	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

\*120\*

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3200F

2:00

6X 12/06/05

M121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83935

**\*83935\***

Page 2

April-27-12 2:51:57 PM

Item ID: D2804-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket Assembly  
 Start Date: 27/04/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 11/05/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				6	BR	126.5	
140 <b>*140*</b> Small Fab Small Fab	Small Fab  Memo Press D2809 into arm as per Dwg D2804	0.00  0.00				6x			ES 12/06/12
150 <b>*150*</b> Small Fab Small Fab	Small Fab  Memo 1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 2-Assemble as per Dwg D2804.	0.00  0.00				6x			ES 12/06/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

April-27-12 2:51:57 PM

**Item ID:** D2804-041

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID:

**Item Name:** Bracket Assembly

Stop \*NS2\*

**Start Date:** 27/04/2012      **Start Qty:** 4.00

**\*4\***

**Cust Item ID:**

**Required Date:** 11/05/2012      **Req'd Qty:** 4.00

**\*4\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

### Operation Description

### Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

170

Identify as per dwg & Stock Location: S1149 0.00

0.00

**\*170\***

## Packaging

## Memo

0.00

## Packaging

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

## Memo

0.00

## Quality Control

12/6/14 JH  
mf  
12-06-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April-27-12 2:52:02 PM

Page 1

Work Order ID: 83935

**\*83935\***

Parent Item: D2804-041

**\*D2804-041\***

Parent Item Name: Bracket Assembly

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM  
IPP Rev:G As per Rev C 06-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2804-1 <b>*D2804-1*</b> Bracket		Manufactured	No			100	Each	1.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST148				1					
				79083				1					
D2805-1 <b>*D2805-1*</b> Stop		Manufactured	No			100	Each	6.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				6					
				79525				6					
NAS1515H3 <b>*NAS1515H3*</b> Washer		Purchased	No			100	Each	190.0000	4	616			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST277				190					
				118078				6					
				119438				4					
				120142				11					
				120518				26					
				120770				43					
				121415				100					

*EB 12/06/05*  
*B83065 (6x)*

*EB 12/06/05*

*EB 12/06/12*

*M121649*  
*(24x)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

April-27-12 2:52:02 PM

Page 2

Work Order ID: 83935

**\*83935\***

Parent Item: D2804-041

**\*D2804-041\***

Parent Item Name: Bracket Assembly

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 4.00

Required Qty: 4.00

AN3C16A

Purchased

No

150

Each

68.0000

2

8

**\*AN3C16A\***

Bolt

\*\*

Location

Loc Qty

Loc Code

ST352

68

115835

1

118422

4

120498

38

121349

25

Manufactured

No

150

Each

40.0000

1

4

\*\*

Location

Loc Qty

Loc Code

GA

24

72735

7

80557

17

ST018

16

34035

12

77292

4

*Handwritten notes:*  
 4/2/06/12  
 10x  
 2 M121652  
 4/2/06/12  
 1x  
 5 B85299

D2809

**\*D2809\***

Bushing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April-27-12 2:52:03 PM

Page 3

Work Order ID: 83935

**\*83935\***

Parent Item: D2804-041

**\*D2804-041\***

Parent Item Name: Bracket Assembly

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

150

Each

1,097.000

2

8

**\*MS21043-3\***

Nut

\*\*

*EB 12/06/12*

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

124

120693

124

ST301

901

118077

2

118614

83

118686

30

119758

20

121255

766

*M121708*  
*(1200)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

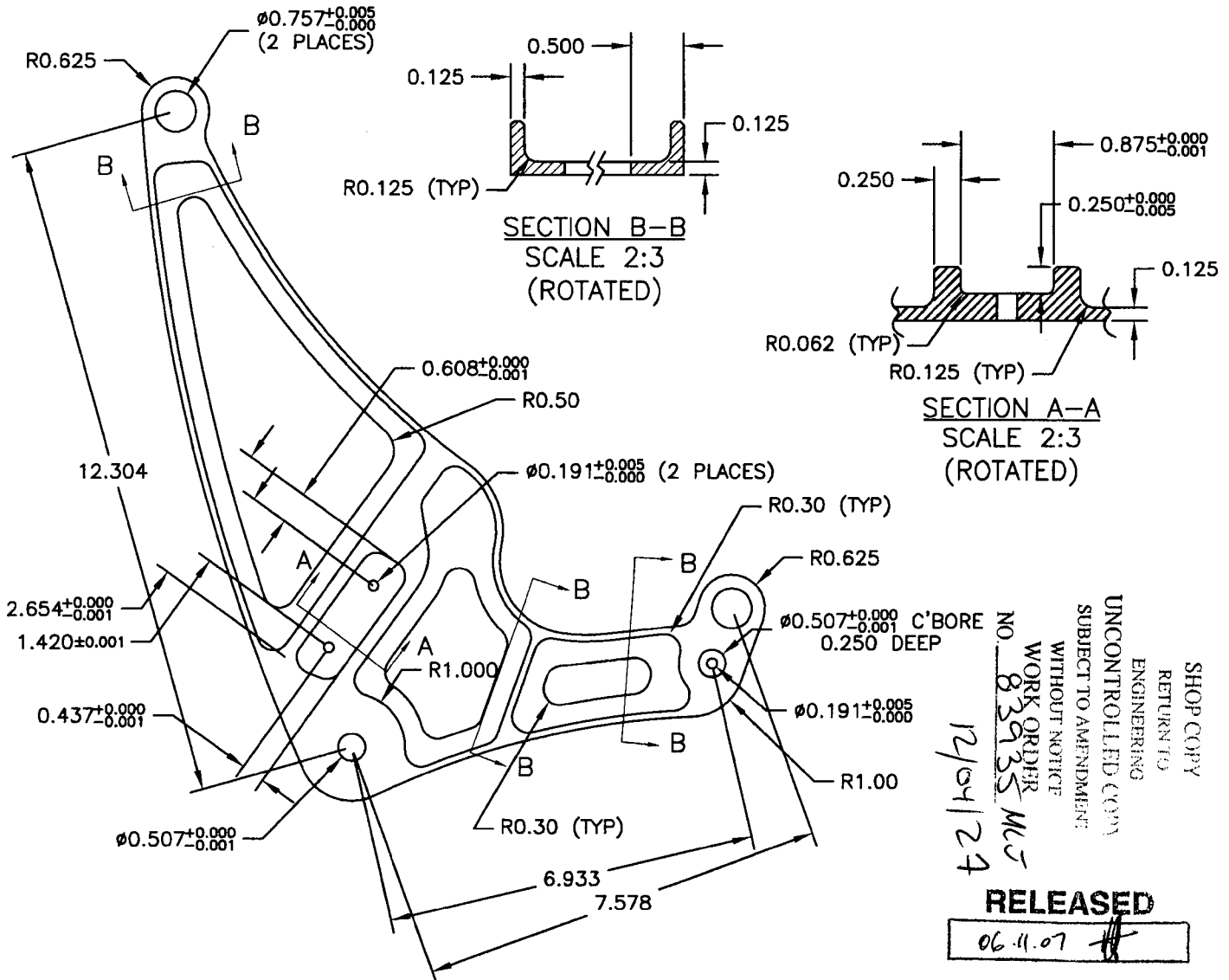
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	



# **D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

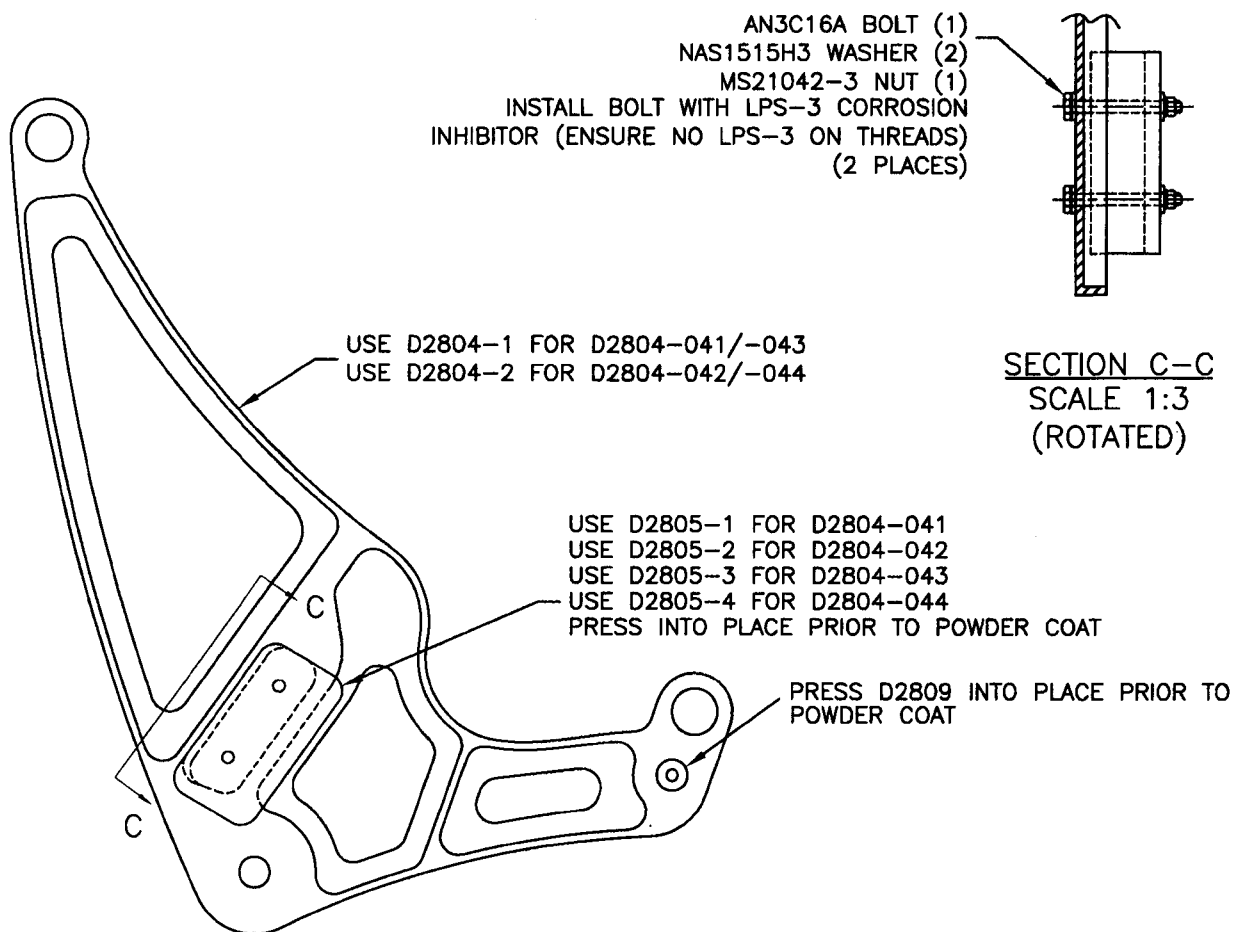
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



02635

RELEASED

06.11.07

D2804-041/-043 BRACKET ASS'Y (SHOWN).  
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries